

# Work Order ID 60348

July 6, 2010 12:59:44 PM

*AOG ship ASAP*



Page 1

Item ID: D3065-5

Revision ID:

Item Name: Step Leg

Start Date: 7/06/10

Start Qty: 4.00

Required Date: 7/07/10

Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3065

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D Dwg Rev: *B* Prog Rev: *B* 2-Deburr  
if necessary

*Deburr = m-l 10/07/07*

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

*Swk 7/10/07*

*ml*

*10 07 06 (4)*

*ml*

*10 07 06 (4)*

*FAI*

# Work Order ID 60348

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Page 2

Item ID: D3065-5

Revision ID:

Item Name: Step Leg

Start Date: 7/06/10 Start Qty: 4.00

Required Date: 7/07/10 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

10107107

4

0

140



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

4

10-7-7

150



Packaging

Packaging

Identify as per dwg & Stock Location CIA

Memo

0.00

0.00

10-7-7

(4) SP

# Work Order ID 60348

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Page 3

Item ID: D3065-5

Revision ID:

Item Name: Step Leg

Start Date: 7/06/10

Start Qty: 4.00

Required Date: 7/07/10

Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control



Accept



Cust Item ID:

Customer:

Setup

Start

Stop



*100707*

*mf*  
*10-7%*

# Picklist Print

July 6, 2010 12:59:43 PM

Work Order ID: 60348

Parent Item: D3065-5

Parent Item Name: Step Leg



Start Date: 7/06/10

Start Qty: 4.00

Required Date: 7/07/10

Required Qty: 4.00

## Comments:

IPP: 11C102.11.01 Incorporated D3066-1 IPP: KJ/RF  
IPP Rev:D Now on Water Jet 06-04-11 JLM  
IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Component Item ID/  
Item Name

Replacement  
Item ID

Mfg/  
Purch

Bin  
Item

Primary  
Location

Last  
Location

Route  
Seq ID

Unit of  
Measure

Qty on  
Hand

Qty per Kit

Total  
Qty

Qty  
Issued

Date  
Issued

Status

M6061T6S.080

Purchased

No

100

sf

89.7699

1.0798

4.546526



6061-T6 .080 Sheet

Location

MAT21

113438

114351

Loc Qty

89.76993

2.7512

87.01873

Loc Code

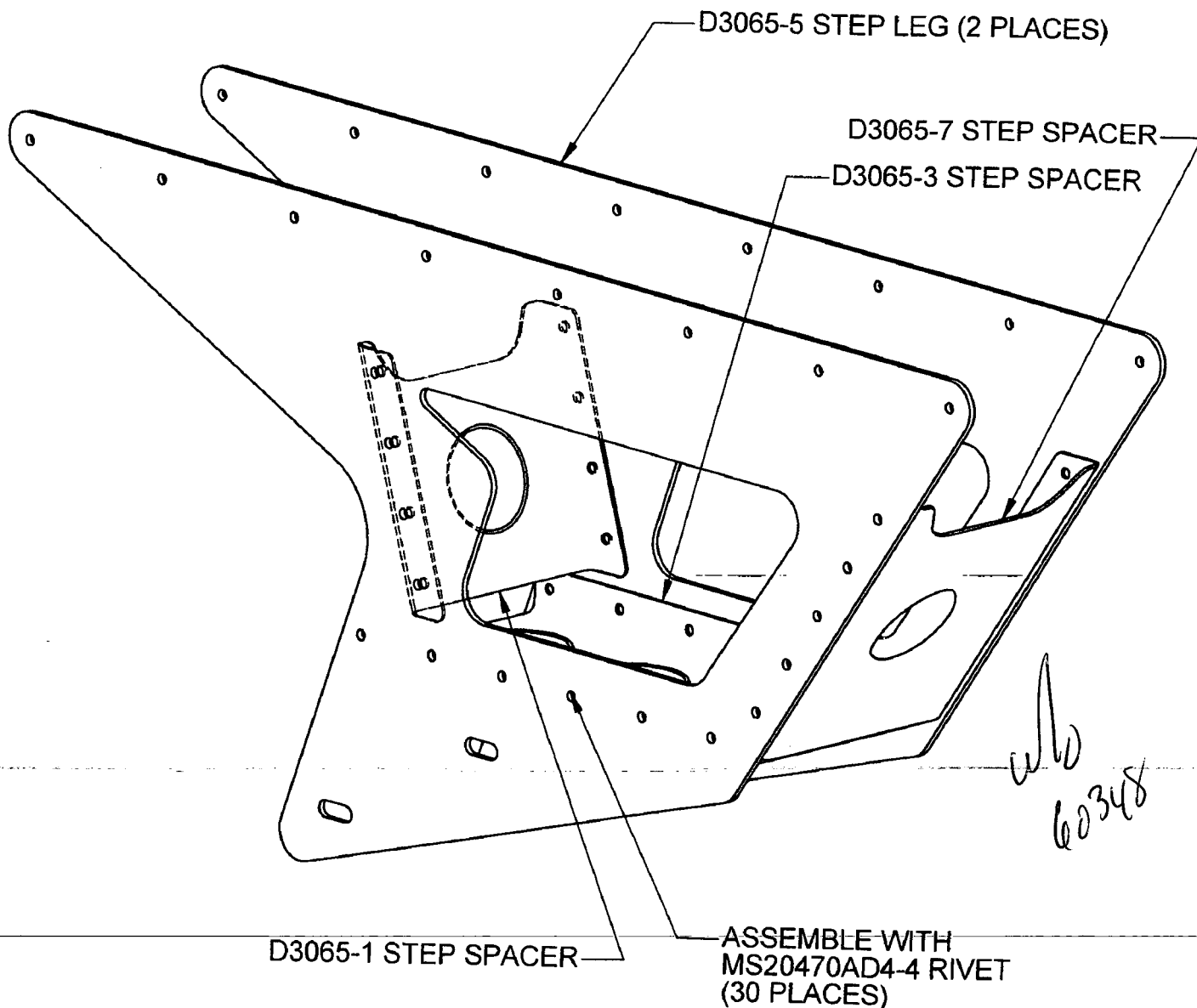
m 10.07.06



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 1 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b> SCALE 1:2	
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06-06-20 *[Signature]*



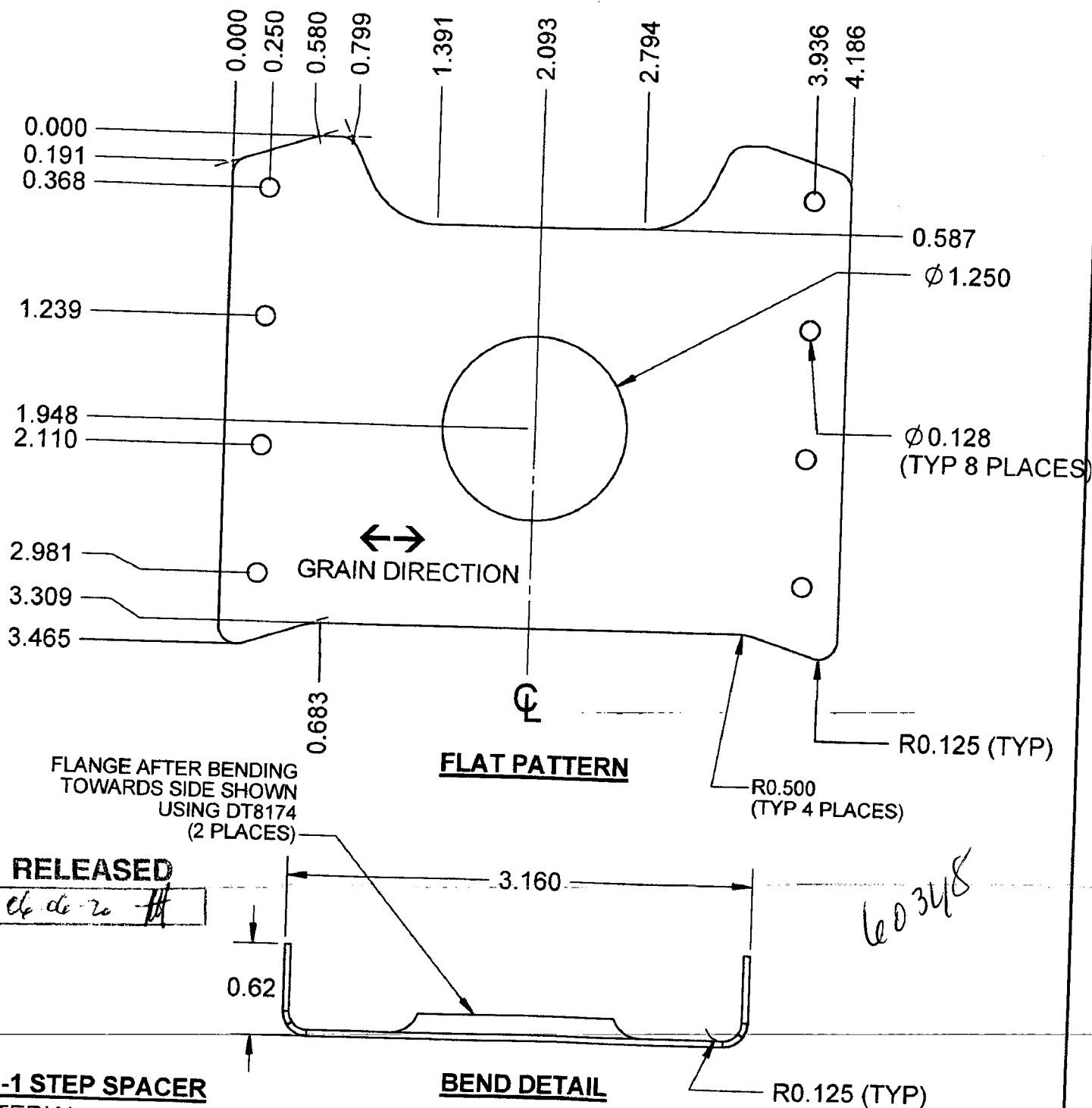
## **D3065-041 STEP LEG ASSEMBLY**

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>
DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>	REV. B SHEET 2 OF 5 SCALE 1:1



### D3065-1 STEP SPACER

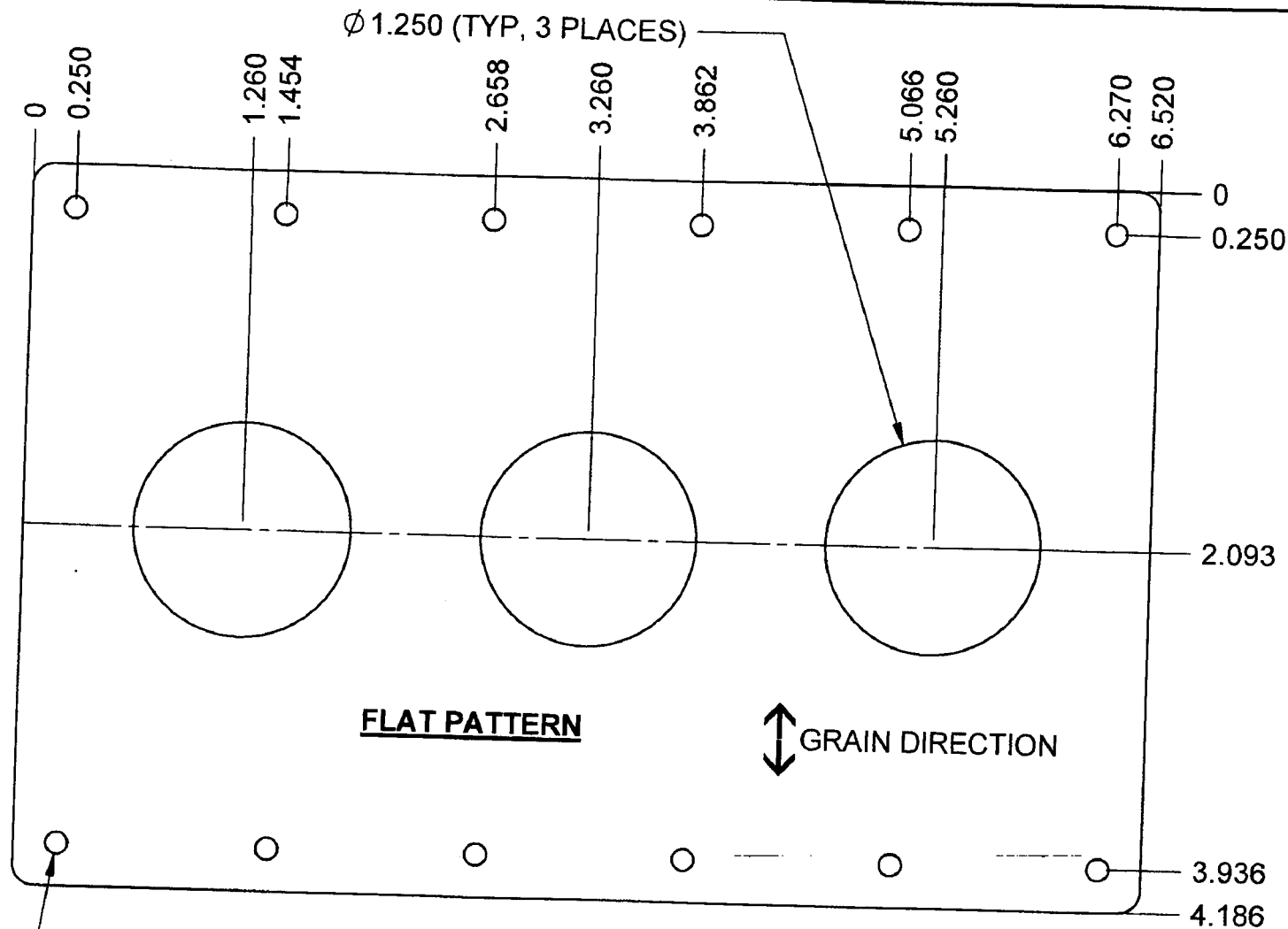
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>
DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>	REV. B SHEET 3 OF 5 SCALE 1:1

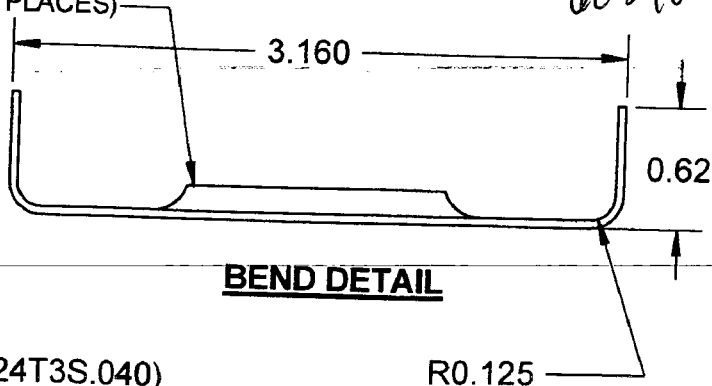


FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)

$\phi 0.129$  (TYP, 12 PLACES)

**RELEASED**

*06 06 20*



### D3065-3 STEP SPACER

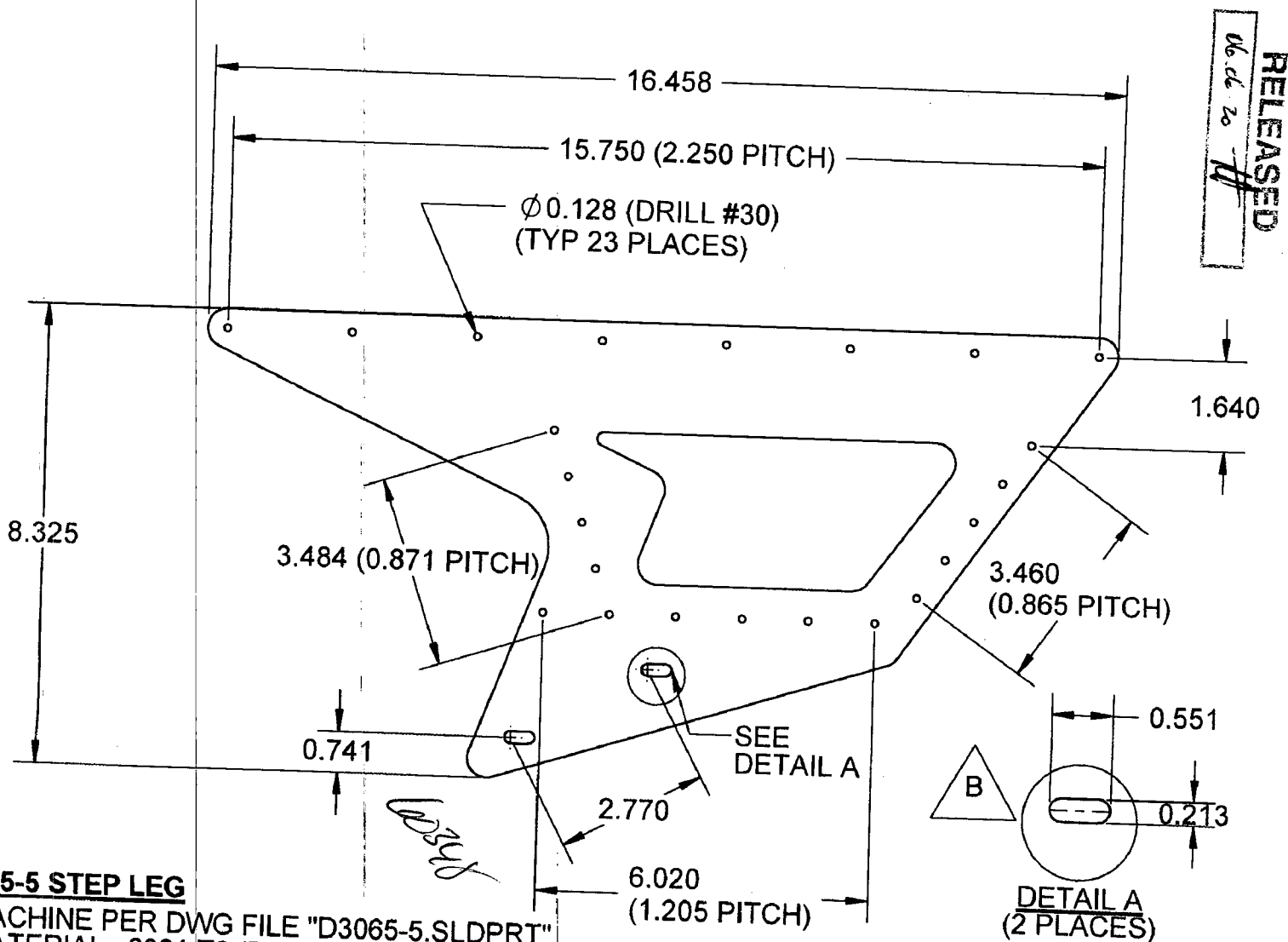
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b>
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
04	04	DRAWING NO.
DATE	06.05.23	D3065
TITLE	STEP LEG ASSEMBLY	REV. B
SCALE	1:3	SHEET 4 OF 5



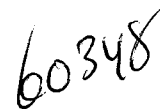
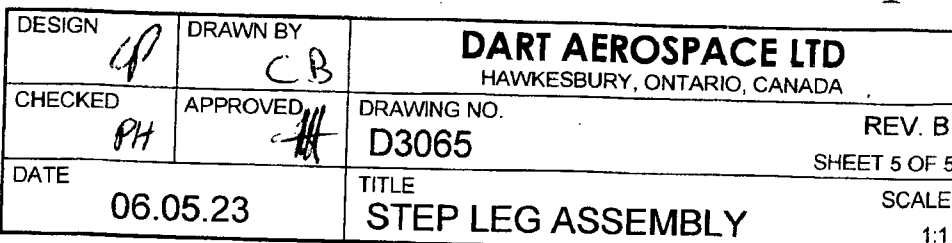
**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRJT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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## FLAT PATTERN

**RELEASED**

06 06 20 

3.160

0.62

**BEND DETAIL**

R0.125 (TYP)

OK OK 20

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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